

Work Order ID 79580

79580

Page 1

January-27-12 3:27:52 PM

Item ID: K10112 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Saddle, Skidtube 206
 Start Date: 27/01/2012 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 10/02/2012 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/12 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9583	A
K10112	B

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP
 FOR D206-642-112 CHG007
 FOR D206-642-114 CHG002

0.00

0.00

K10112 CHG003

5/12/12

MLJ 12-2-29

(5)

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

12/2/29 5/5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Start Date: 27/01/2012 Start Qty: 5.00 ***5*** Cust Item ID:
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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Insp kits for completeness Memo	0.00 0.00							
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP PPP D206-642-111 PPP D206-642-113 Location: PK PPP rev: E	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

(Signature)

12/3/12 sp (JC)

12/3/12 (Signature)

12-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 79580

79580

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: E00.06.14Changed GHW part # (mpp 2063)ECIPP REV:F
11.09.23 PER REV.B DD VERF:EC IPP REV:G 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-41A		Purchased	No			110	Each	735.0000	8	40			
AN3-41A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST354				735					
				119042				735		40			
AN4-6A		Purchased	No			110	Each	3,130.000	12	60			
AN4-6A									**				
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				3130					
				119017				3130		60			
AN4C5A		Purchased	No			110	Each	370.0000	1	5			
AN4C5A									**				
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP002				18					
				112243				18					
				ST355				352					
				112243				252					
				119017				100					

12/2/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

AN5-10A

Purchased

No

110

Each

500.0000

4

20

AN5-10A

Bolt

**

Location

Loc Qty

Loc Code

ST337

500

118191

80

119547

320

119981

100

AN5-11A

Purchased

No

110

Each

1,139.000

4

20

AN5-11A

Bolt

**

Location

Loc Qty

Loc Code

ST337

1139

118191

13

119512

1126

AN6-44A

Purchased

No

110

Each

289.0000

2

10

AN6-44A

Bolt

**

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

282

119036

282

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 79580

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Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D206-651-041

CH67101

Manufactured No

110 Each 59.0000

1

5

D206-651-041

206A/B GHW

**

5

Location

Loc Qty

Loc Code

FG

8

78659

8

FG120

1

76578

1

FG122

50

77866

50

D2652

Manufactured No

110 Each 943.0000

16

80

D2652

Bushing

**

80

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

899

73834

15

73836

36

76132

48

76135

400

77135

400

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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January-27-12 3:27:56 PM

Work Order ID: 79580

79580

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D2661-2

Manufactured No

110

Each

40.0000

2 10

D2661-2

Saddle, RH Fwd Aft Out 206

**

Handwritten notes: 6, 379202, and other markings.

Location

Loc Qty

Loc Code

MEZZ

6

10015

1

10016

1

10476

3

9913

1

ST429

10

78140

10

ST435

24

76763

4

78141

10

78142

10

Handwritten '2' and '2'.

D2662-2

Manufactured No

110

Each

35.0000

2 10

D2662-2

Saddle, RH In 206

**

Handwritten notes: 379196, 126629, and other markings.

Location

Loc Qty

Loc Code

Mezz

2

11028

4

9042

3

9043

2

ST435

20

78154

10

78156

10

ST483

6

78155

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 79580

79580

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D2712 Manufactured No

110 Each 1,362.000 10 50

D2712

Set Screw

**

sf

Location

Loc Qty

Loc Code

FG 50

29962 50

ST021 1312

76065 1312

SO

D2884 Manufactured No

110 Each 319.0000 2 10

D2884

Saddle Spacer

**

sd

Location

Loc Qty

Loc Code

FG 10

29453 10

ST020 309

76751 309

10

D2885 Manufactured No

110 Each 310.0000 2 10

D2885

Saddle Spacer

**

12/2/28 sf SO

Location

Loc Qty

Loc Code

FG 10

29199 10

ST020 300

76752 300

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 79580

Parent Item: K10112

Parent Item Name: Saddle, Skidtube 206

79580

K10112

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

D3413-1

Manufactured No

110

Each

89.0000

1

5

**

B77940^{SD}

SP

D3413-1

Ring

Location

Loc Qty

Loc Code

ST420

2

66387

1

70773

1

ST464

87

75478

28

76754

59

MS21042L3

Purchased

No

110

Each

5,393.000

8

40

**

SP

MS21042I 3

Nut

Location

Loc Qty

Loc Code

ST300

5393

117441

16

117885

32

118451

5

118927

3

119017

4917

119075

420

MS21042L4

Purchased

No

110

Each

6,617.000

12

60

**

12/2/28 SD

MS21042I 4

Nut

Location

Loc Qty

Loc Code

ST300

6617

117441

51

117601

237

118451

133

119017

1196

119075

5000

60

January-27-12 3:27:56 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 79580

79580

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L6

Purchased

No

110

Each

1,202.000

2

10

MS21042L6

**

Nut

Location

Loc Qty

Loc Code

ST300

1202

117677

25

118384

3

118927

48

119075

926

120308

200

10

NAS1149C0463R

Purchased

No

110

Each

1,242.000

1

5

NAS1149C0463R

**

Washer

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

1241

117735

241

119097

1000

5

NAS1149D0363J

Purchased

No

110

Each

3,315.000

8

40

NAS1149D0363J

**

Washer

Location

Loc Qty

Loc Code

ST298

3315

117601

61

118077

1

118612

18

119537

942

120142

1293

120308

1000

40

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 79580

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Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 27/01/2012

Required Date: 10/02/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

110

Each

4,267.000

24

120

32x

20

NAS1149D0463.I

Washer

**

sf m117042 m112460

Location

Loc Qty

Loc Code

ST298

4267

116805

0

118384

135

118612

3

119075

3960

119097

169

72080

NAS1149D0563J

Purchased

No

110

Each

4,502.000

8-

40

NAS1149D0563.I

Washer

**

sf

Location

Loc Qty

Loc Code

ST298

4502

118206

510

118614

1000

119546

2000

119717

992

40

NAS1149D0663J

Purchased

No

110

Each

1,076.000

4

20

NAS1149D0663.I

Washer

**

12/2/27 B D

Location

Loc Qty

Loc Code

ST298

1076

119075

1076

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-112
BELL 206 A/B	D206-642-114

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10112	D206-642-112	D206-642-114
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-2	2	2	2
5	D2662-2	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-114	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	K10112	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	